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Item ID: Revision ID: Item Name: Start Date: Required Date:	28/03/2012	Closeout Installation Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept	*N900 Cust Item I Customer:		100)* S	etup	Start Stop	*NS	\$1* \$2*	
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Work Order ID: 82285

82285

Parent Item:

D350-567-141

• Parent Item Name: Floor Window Closeout Installation

D350-567-141

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A 11.11.09 new issue DD verf:JLM

12.01.23 AS PER ECN12-511 DD VERF:EC

IPP REV:B IPP REV:C 12.03.05

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	-	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1		Manufactured	No			110	f	557.7500	2	12			
D3802-1 Window Seal									**				
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D4434-041

Fwd Bracket Assembly

Cover Assembly

D4435-045

Manufactured

Manufactured

Manufactured

No

No

No

110 Each 0.0000

Each

Each

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0.0000

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Location Loc Oty Loc Code ST-441 19 80650 10 80651

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					Sta	art Qty: 6.00	Required Qty: 6.00
D4435-9 *D4435-9* 6 Bracket	Manufactured	No		110 Each	39.0000	** 87 93 47	
- Bracket			<u>Location</u> ST441 80659	Loc Oty 39 39	Loc Code	4 × 875	-
D4436-041 *D4436-041* Aft Bracket Assembly	Manufactured	No	80039	110 Each	0.0000	** 4 × 8228	6 JB 🔊
S.d.			<u>Location</u> ST ST441	<u>Loc Otv</u> -9	Loc Code	2 x 851	561 8P.
D4441-1 *D4441-1 Rubber Seal	Manufactured	No		110 f	182.6290	2 12	JB 12/09/25
(D4441-1-240) (CUT, (1) AT 24.00" PER KIT) 12 1		Location prelim 74760 ST413 79385 80763	6.739 6.739 175.89 165.99 9.9	Loc Code	8076	- - - - -
AN3-3A* Bolt	Purchased	No		110 Each	701.0000	1 42 / ** 3× 122416	JB 12/09/21
			<u>Location</u>	Loc Oty	Loc Code		-

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Location

ST300 370 118354 119109 119758 120360 366 Purchased No 110 388.0000 Each

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ST300	388		
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER

AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER

REF CANADIAN STC: SH92-18 FAA STC: SH989NE FAA STC: SH990NE

1.0 **Purpose**

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

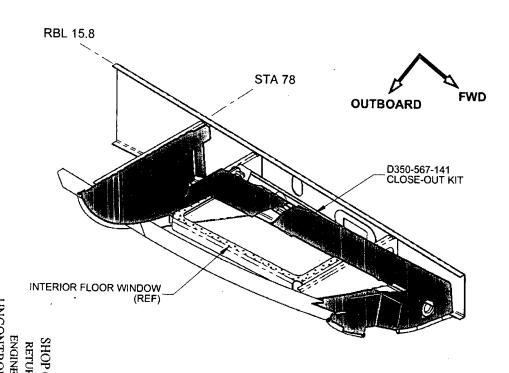


Figure 1. Floor Window Close-out Kit Installation

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BY: MX	PROVED ERD (DE # 02)
DATE: CERT. NO.: ISSUE NO.:	12.03.13 SH92-18 6

SUBJECT TO AMENDM

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			RF	12.03.13				
В	MS3520 WAS (Q 832R7,	6-229 WAS AN ty 9); MS21042 NAS1149FN882	RF 12.02.22					
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MFG. A	PPR.	N/A	DSI 9590		SHEET 1 OF 12			
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DATE 12.03.13			COPYRIGHT © 2012 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNIC WRITTEN PERMISSION FROM DART AFF	ON THE EXPRES	S CONDITION THAT IT IS			

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2.0 Part List

Qty -141	Part Number	Description
Х	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14_	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Landa Made		LA	TERAL	LONG	ITUDINAL
Installation	Weight	Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit.
The procedure that follows outlines the step-by-step procedures for installing the kit with
reference photos from the initial installation.

2) In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.

D350-567-115 — OK to remove D3295-041 D350-567-031 — OK to remove D3212-1

D350-567-011 — OK to remove D2214 D350-567-021 — OK to remove D2951

3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

DATE: 12.03.13 CERT. NO.: SH92-18 ISSUE NO.: 6

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DE APPR.	#	FLOOR WINDOW CLOSE-OUT KIT NTS				
DATE 12.0	3.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMBENIATED TO ANY OTHER PERSON WITHOUT IT				

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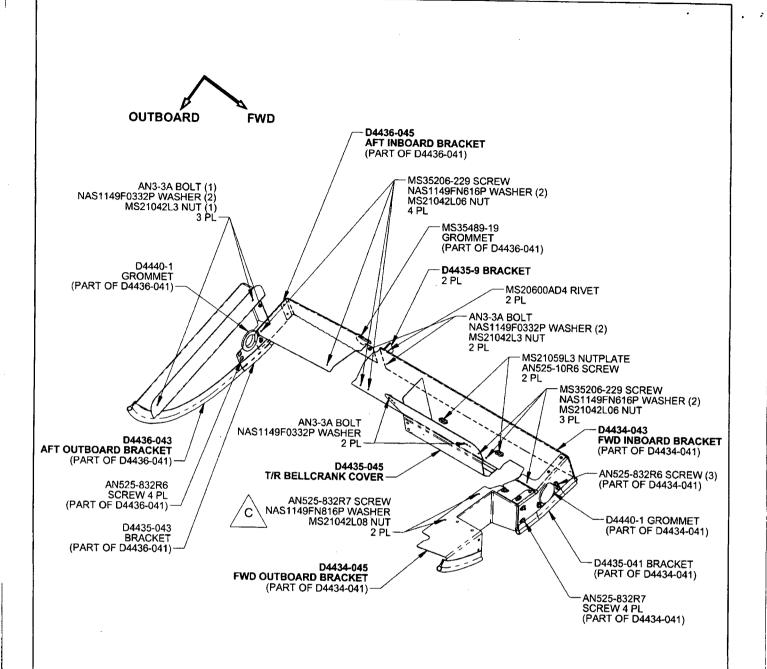


Figure 2. Floor Window Close-out Kit Installation

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

APPROVED D. SHEPHERD (DE # 02)

CERT. NO.: ISSUE NO .:

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- Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before 4.1 drilling holes:
 - Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm 4.2 there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in
- If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required
- Drill off rivets holding plastic wire bundle stand offs. Transfer drill ø0.144 holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x ø0.144 holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x ø0.144 holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9. 4.5
- Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x Ø0.129 holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to ø0.191. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- Transfer drill 2 x ø0.144 holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, 4.8 drill 2 x Ø0.144 holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.



- Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x ø0.098 holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to ø0.191 and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

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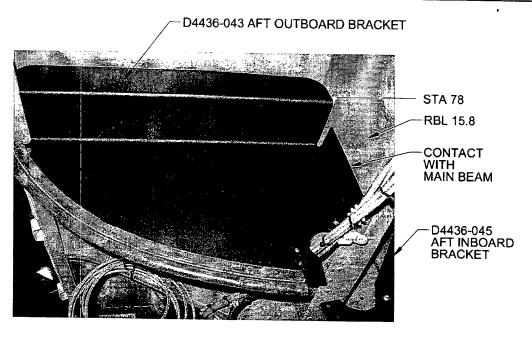


Figure 3. D4436-043 Aft Outboard Bracket Installation

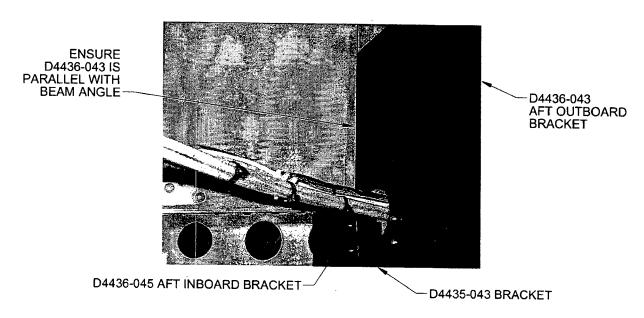


Figure 4. D4436-043 & D4435-043 Brackets Installation

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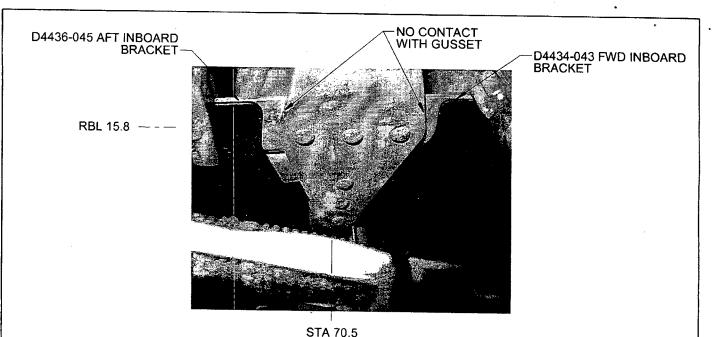


Figure 5. D4436-045 & D4434-043 Brackets Installation

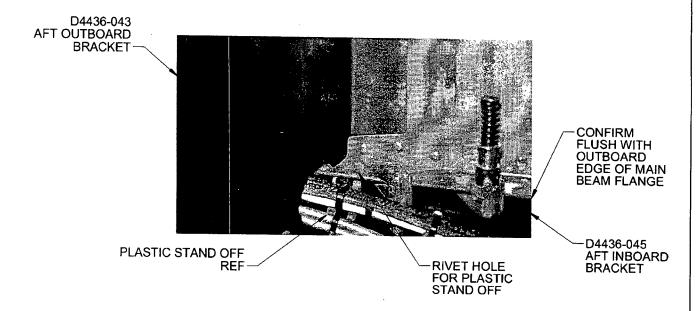


Figure 6. D4436-043 & D4436-045 Brackets Installation

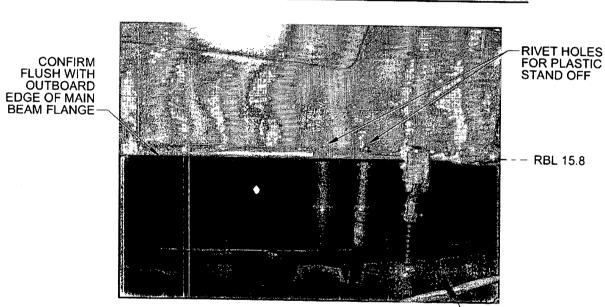


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CONFIRM FLUSH WITH RIVET HOLES OUTBOARD FOR PLASTIC STAND OFF EDGE OF MAIN **BEAM FLANGE** -- RBL 15.8 D4436-045 AFT INBOARD BRACKET. PLASTIC STAND OFF D4434-043 FWD INBOARD **REF**

Figure 7. D4434-043 & D4436-045 Brackets Installation



D4434-043 FWD INBOARD BRACKET

BRACKET

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Figure 8. D4434-043 Fwd Inboard Bracket Installation

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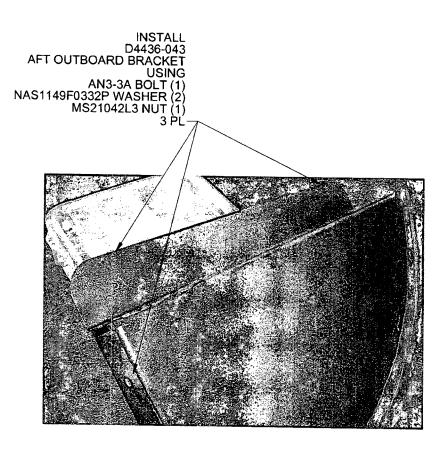


Figure 9. D4436-043 Aft Outboard Bracket Installation

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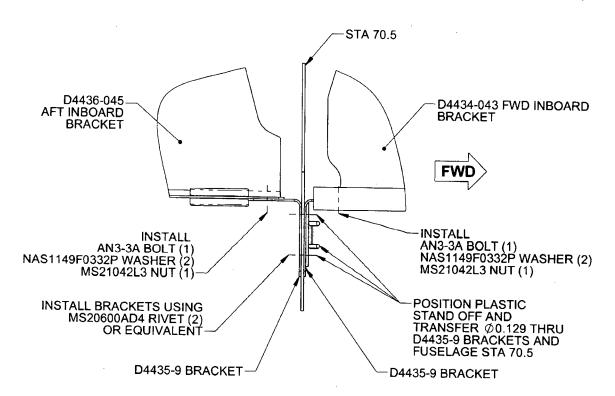
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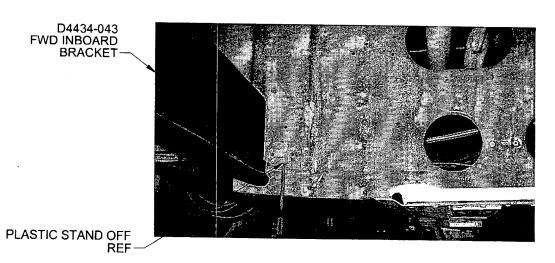


Figure 10. D4434-043 and D4435-9 Brackets Installation

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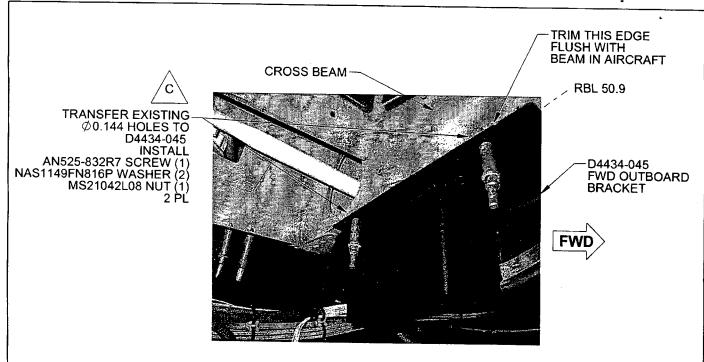


Figure 11. D4434-045 Bracket Installation

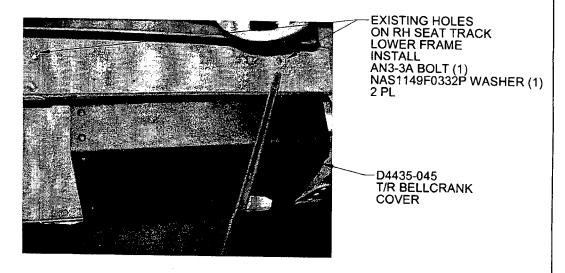


Figure 12. D4435-045 T/R Bellcrank Cover Installation

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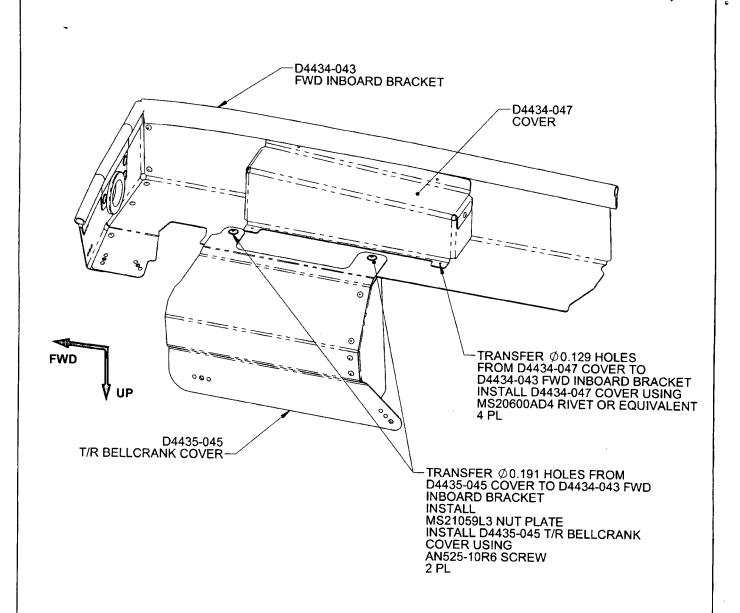


Figure 13. D4435-045 & D4434-047 Cover Installation

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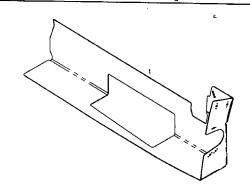
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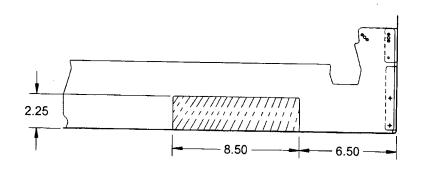
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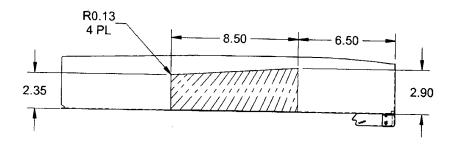


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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REFERENCE ONLY

2.0 Part List

Qty -141	Part Number	Description			
Х	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT			
1 1	D3802-1-024	SEAL (24")			
<u></u>	D4434-041 = 7	FWD BRACKET ASSEMBLY			
1	D4434-047 /	COVER ASSEMBLY			
7 1	D4435-045	T/R BELLCRANK COVER ASSEMBLY			
7 2	D4435-9 ,	BRACKET			
1	D4436-041	7AFT BRACKET ASSEMBLY			
) 1	D4441-1-240	RUBBER SEAL (24")			
77	AN3-3A	BOLT			
1 2	AN525-832R7	-SCREW			
7	MS21042L06	NUT;(OR MS21042-06)			
1_2_	==MS21042L08	NUT (OR MS21042-08)			
/ 5	MS21042L3	NUT (OR MS21042-3)			
2 -	*MS21059L3	NUTPLATE			
1 7	MS35206-229	. SCREW			
/ 12	NAS1149F0332P	"WASHER (AN960-10L)			
<u>_14</u>	NAS1149FN616P	*WASHER (OR AN960-6L)			
12	NAS1149FN816P	-WASHER (OR AN960-8L)			



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

		LATERAL		LONGITUDINAL	
Installation	Weight	Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- 1) Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.

D350-567-115 — OK to remove D3295-041

D350-567-031 — OK to remove D3212-1

D350-567-011 — OK to remove D2214

D350-567-021 — OK to remove D2951

3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA
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BRANCH
DAO#01-O-01

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